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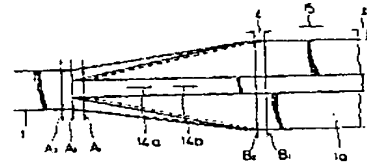
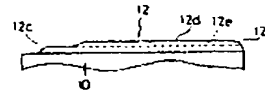
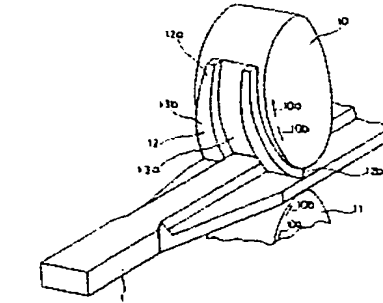
APPLICATION DATE : 10-01-89
APPLICATION NUMBER : 01003425

APPLICANT : KOBE STEEL LTD;

INVENTOR : MIKUNI TOSHIHIKO;

INT.CL. : B21H 8/00 B21B 1/42

TITLE : MANUFACTURE OF ROLLED
DEFORMED BAR STOCK



ABSTRACT : PURPOSE: To perform rolling at a speed two times as much as the the conventional one by returning bar material to be worked by a prescribed distance after rolling rolls for profiles make a normal rotation and rolling it in time of reversing rolls, too.

CONSTITUTION: Rolls 10, 11 are rotated in the direction of normal rotation 10a. First, the tip part 12a of a projecting part 12 bites a stock 1 and rolls it while it moves to the rear end part 12b. The stock 1 receives the start of working at point A₁, is rolled while it moves in the direction of an arrow 14a, completes rolling at point B₁ and a triangular pattern shown by broken lines is copied on the stock 1. Since the rear end surface 12b of the projecting part 12 is rounded off, the projecting part 12 does not come into contact with the stock 1. The stock 1 is fed forcibly by an amount of feed (l) in the direction of an arrow 15 and point B₂ is positioned between the rolls 10, 11. When the rolls 10, 11 are driven reversely in the direction of an arrow 10b, a triangular pattern by the full line is copied between points A₂ and B₂ of the stock 1 and rolling is carried out in time of the reverse rotation, too.

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